

5/14

DART AEROSPACE LTD		Work Order:	22636
Description: Angle		Part Number:	D3247-1
Dwg: D3247 Rev. A		Qty:	40
		Page 1 of 1	

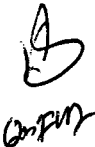
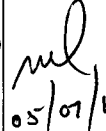



Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PTJ	05.03.09	40
2	PG	Issue P/O: <u>207692</u> Fabricate D3247-1 as per Dwg D3247 Possible Supplier: Industrial Laser Material release note is required	LU	05.03.10	40
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CL	05/06/08	40
4	QC6	Inspect dimensions as per Dwg D3247	ml	05/07/11	40
5	GA	Deburr	ml	05/07/15	40
6	FP	Chemical Conversion Coat as per QSI 005 4.1	PMC	05-7-26	40
7	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC	05-8-2	40
8	QC3	Inspect Powder Coat	MM	05 08 03	40
9	ST	Identify and Stock	DL	05/08/03	40
10	AC	Cost / part			
11	DC	Close W/O Inspect Level 21			

PTO

Rev	Date	Change	Revised By	Approved
A	04.05.25	New issue	KJ/JLM	
B	04.10.26	D3247-1 no longer made in-house	KJ/JLM	

RELEASED
2/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/07/11	4	The dimension are good except $\phi .098$ of 34 holes: should be .098		Re-do 34 $\phi .098$ Holes as per drawing $\# 3247$	 05/07/11	 05/07/11	 05/07/11	 05/07/11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

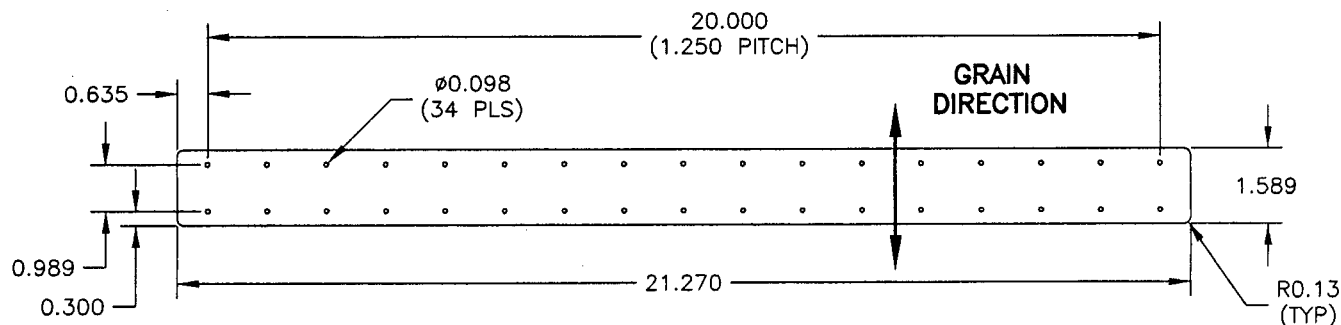
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

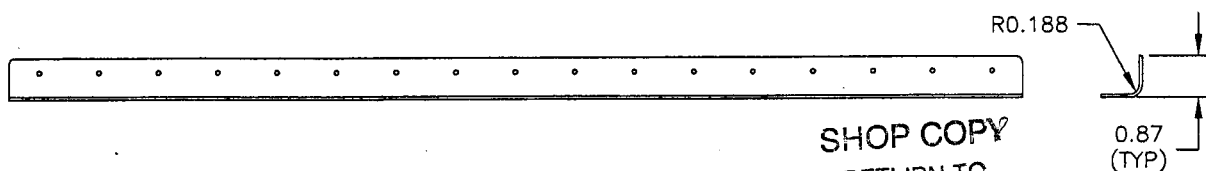


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D3247	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE ANGLE	SCALE 1:4
A	04.04.06	NEW ISSUE	

RELEASED
04.04.27



FLAT PATTERN



D3247-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBMIT TO ELEMENT
WHICH ISSUE

WORK ORDER

NO. 22636

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

763 717 7112 P.02/03 MTR MINNEAPOLIS 002

CERTIFIED INSPECTION REPORT

We hereby certify that all the material covered by this affidavit has been inspected with, and has been found to meet, the applicable requirements described therein, including any specific laws forming a part of the decision and that there has been no change in the material since the composition firms and had it a mechanical prop under shown on the face of this sheet.

Wm. J. Baker

Walter J. Vachon
Director of Manufacturing Development Work

Letting

Kenton P. Young
Quality Assurance Manager

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

13 23 23
Ship Date

28027
B.L. No.

Invoice No.

Alc No. Item

PAGE 1

2805-01-11

67993

81819

DE-64819-1

P.O. No./Govt Contract No.

Customer

419344:20050119

INTEGRALS BETL-COON

Ship To: INTEGRIS METALS
455 85TH AVE. NW
COON RAPIDS, MN 55433

Item Description

ITEM DESCRIPTION
0.0318 IN TK X 48.000 IN W X 144.000 IN LB CAT D 126153 (N) A/T 2024-
73 FLAT SHEET MILL FINISH (P/N 54184155). PER AMS-QQ-A-
250/1 REV A & (EXCEPT OIL &
WARNING) REV 027 REV N = (EXCEPT WARNING)
ASTM208 REV 04 ((MARKED)) INTERLEAVED SMID
WGT: 4500 LB QUAN TOL +/-10 %
QDR D126153 REV 26 QRR 002776 CUST REQ 05-01-
19 *** W/E 05-01-22 ***

Mms	Package Ticket	Lot	Weight	Quantity	UCM	Pc Id/Serl
1	249883	753041	1932	45	PC	

Notes for COA: D126153-26

Notes for CCR: 0126153-26
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 1.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

COR: D126151.26 -Specification Limits

			UTS	YS	EL60								
Dupe Dir			KSI	MSI	PC7								
TJ Long Transv.	Max												
	Min		61.0	62.0	35								
						Other Other							
Chemical Composition			SI	FE	CU	MN	MG	CA	ZN	PB	EACH	TOTAL	ALUMINUM
	Max		.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15	
Alloy 2024	Min				3.8	.30	1.2						REMAIN

Lot: 758461 -Mechanical, Physical, Metallography, Quantumeter Results

		No.	URS	TYS	HL40
Temp	Dir	Test	KSI	KSI	PCT
T3	Long Transv.	6	Max 67.7	45.9	20
			Min 67.2	45.7	16

INTF6015 O/N 359124

06/02/05 THU 10:15 FAX 604 272 0951
Integris Metals 6/2/2005 11:58

INTEGRIS METALS
PAGE 002/002 Fax Server

04/01/05 FRI 14:03 FAX 604 272 0951
APR-01-2005 13:46 INTEGRIS METALS

INTEGRIS METALS

MTR MINNEAPOLIS
763 717 7112 P.03/03

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA LAFAYETTE, MISSOURI
Ship From: ALABAMA, AL.

Page 2

TOTAL P.0

The undersigned hereby certifies that the inspection was conducted in accordance with the requirements of the contract and that the inspection was conducted in accordance with the requirements of the contract and that the inspection was conducted in accordance with the requirements of the contract.

Handwritten Signature
Inspector of Manufacturing Operations/Quality

Handwritten Signature
Quality Assurance Manager

Lot: 758041 - Mechanical, Physical, Metallurgy, Quantometer Results (cont.)
Cast Number: Chemical 81 PE CU NI PB CR ZN TI
Actuals: .87 .18 4.5 .63 1.5 .01 .08 .01

332323 20017
Ship Date: 2005-01-21 67991
Bl. No.
Invoice No. 81618
Alcoa No. Item DS-64819-1
P.O. No./Contract No. 419444:20050119
Customer: INTEGRIS STL-COON